

Date: Friday, 5/25/2007 12:53:30 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FLOOR WINDOW
Job Number : 32689	
Estimate Number : 10848	
P.O. Number : <i>N/A</i>	Part Number : D3295041
This Issue : 5/25/2007	Drawing Number : D3295 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i>	Drawing Revision : C
Previous Run : 32287	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 6/7/2007
Checked & Approved By : <i>[Signature]</i>	Qty: 20 Um: Each
Comment : Est. C 05.06.20 D3295-1 no longer made in-house KJ/JL M Est Rev:D Added DT8822 07-03-20 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MACRLICS125	1/8" Polycast II Sheet
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M103735



Comment: Qty.: 1.2500 sf(s)/Unit Total : 25.0000 sf(s)
Window

Pick:

Qty	Part Number	Description	Batch
1	D3295-1	Window	<i>N/A</i>

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: make per drwg D3295 Rev.C

J.F. 07/06/03

(19) [Signature]

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: DIMENSIONAL CHECK AS PER DT8822 TEMPLATE

J.F. 07/06/03

(19) [Signature]

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*En 07/06/04 [Signature]
P70
x18*

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr if necessary

m2 07/06/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/06/08	8	split - 1 req'd to finish 165	W. O. Fabros				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: 2 Date: 07/06/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/06/08	3	one part is scrap because the material is crack		SCRAP / destroy and no Replacer	J.F. 07/06/08	 07/06/08		 07/06/08

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 12:53:30 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR WINDOW

Job Number: 32689

Part Number: D3295041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D27281

Dart Logo label small



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Dart Logo label small

Assemble as per Dwg D3295.

Put window in plastic wrap.

Pick:

Qty	Part Number	Description
1	D2728-1	Decal

Batch

B24215

✓
mulo7/06/05

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/06/06 (18)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

CP 07/06/07 (18)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(18)

Comment: FINAL INSPECTION/W/O RELEASE

Final 108

Job Completion



U 07/06/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

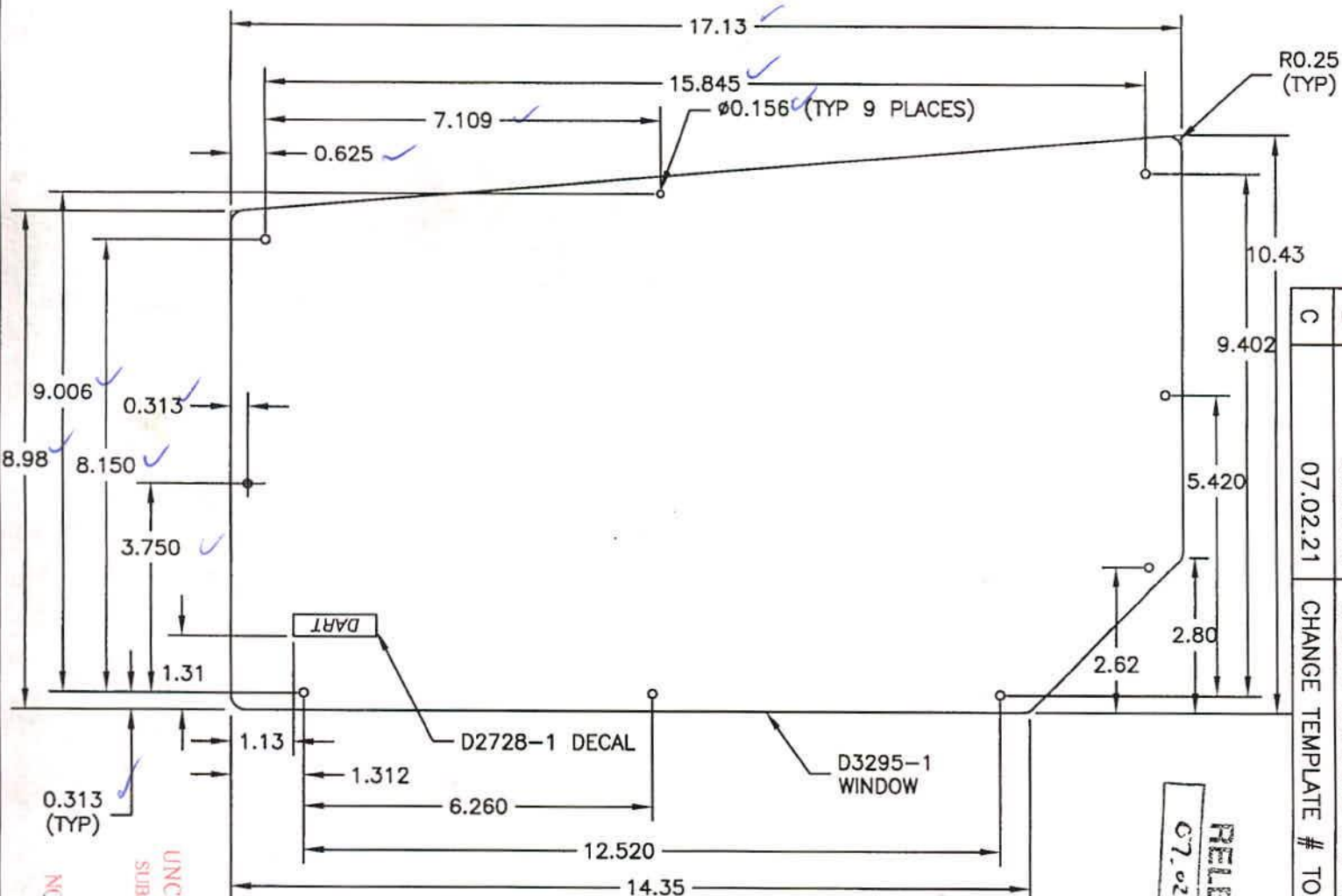
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. C
CP	SSH	DRAWING NO. D3295		SHEET 1 OF 1
CHECKED	APPROVED	DATE		SCALE
		07.02.21		1:3
A	04.06.28	NEW ISSUE		
B	06.04.13	UPDATE MATERIAL PER NCR 029		
C	07.02.21	CHANGE TEMPLATE # TO DT8822		



D3295-041 FLOOR WINDOW

- 1) CHECK DIMENSION WITH TEMPLATE DT8822
- 2) DIMENSIONS ARE IN INCHES AND ARE FOR REFERENCE ONLY
- 3) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK (REF. DART SPEC. M-ACRYLIC-S.125)
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 32689

DART AEROSPACE LTD		Work Order: 32689
Description: Floor Window		Part Number: D3295-1
Inspection Dwg: D3295 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 156"	+0.005" -0.001"	Ø 156"				
17.13"	±0.030"	17.130"				
15.845"	±0.010"	15.845"				
7.109"	±0.010"	7.109"				
6.25"	±0.010"	6.28"				
3.13"	±0.010"	3.15"				
9.006"	±0.010"	9.006"				
8.98"	±0.030"	8.980"				
8.150"	±0.010"	8.150"				
3.750"	±0.010"	3.750"				
3.13"	±0.010"	3.11"				
1.312"	±0.010"	1.317"				
6.260"	±0.010"	6.260"				
12.520"	±0.010"	12.520"				
14.35"	±0.030"	14.35"				
2.62"	±0.030"	2.611"				
2.80"	±0.030"	2.800"				
5.420"	±0.010"	5.420"				
9.402"	±0.010"	9.402"				
10.43"	±0.030"	10.401"				
R0.250"	±0.030"	R0.250"				

Measured by: J.F.	Audited by: Sn	Prototype Approval: u/3
Date: 07/06/03	Date: 07/06/03	Date: u/3

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	